

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 64527

Tuesday, December 07, 2010 11:35:25 AM

Page 2

Item ID: D3196-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Bar

Start Date: 12/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

MA 10/12/16

4

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

4

BR 10-12-16

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:45

OVEN TEMPERATURE:

320° FINISH TIME:

2:15

4

BR 10-12-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 64527

Tuesday, December 07, 2010 11:35:25 AM

Page 3

Item ID: D3196-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Bar

Start Date: 12/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JH 10/12/17

x4

Ø

170

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

C19/12/17 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/17 JH

C210112/17

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 07, 2010 11:35:25 AM

Page 1

Work Order ID: 64527



Parent Item: D3196-4



Parent Item Name: Bar

Start Date: 12/8/2010

Required Date: 12/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6B0.750X01.50
0

Purchased

No

100

f

10.8310

2.89

12.16842



6061-T6 Bar .750 X 1.50

22 10/12/15

Location

Loc Qty

Loc Code

MAT

7.831

116135

7.831

MAT028

3

114968

3

116405

12.2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|-----------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 64527 |
| Description: Bar | | Part Number: D3196-4 |
| Inspection Dwg: D3196 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------------|------------------|--------|--------|----------------------|----------|
| 34.625 | +/-0.010 | 34.625 | ✓ | | m-tape | |
| 33.650 | +/-0.010 | 33.650 | ✓ | | m-tape | |
| 16.639 | +/-0.010 | 16.637 | ✓ | | H-G | |
| 0.488 | +/-0.010 | 0.488 | ✓ | | Vern J1-3 | |
| 0.962 | +/-0.005 | 0.962 | ✓ | | " | |
| 0.464 | +/-0.010 | 0.460 | ✓ | | Vern J1-3 | |
| 0.504 | +/-0.010 | 0.495 | ✓ | | " | |
| Ø0.344 | +0.006/-0.001 | 0.345 | ✓ | | " | |
| Ø0.660 x 100° | +0.008/-0.001 x 0.5° | 0.665 x 100° | ✓ | | " | |
| 0.512 | +/-0.005 | 0.515 | ✓ | | " | |
| 0.060 x 45° | +/-0.010 x 0.5° | 0.061 x 45° | ✓ | | " | |
| 4.750 | +/-0.010 | 4.750 | ✓ | | " | |
| 12.531 | +/-0.010 | 12.533 | ✓ | | H-G | |
| 16.627 | +/-0.010 | 16.627 | ✓ | | H-G | |
| 21.844 | +/-0.010 | 21.844 | ✓ | | | |
| 29.625 | +/-0.010 | 29.625 | ✓ | | | |
| 0.250 | +/-0.010 | 0.251 | ✓ | | | |
| 1.000 | +/-0.010 | 1.000 | ✓ | | | |
| R0.125 | +/-0.010 | 0.125 | ✓ | | R-G | |
| 0.987 | +/-0.010 | 0.988 | ✓ | | | |
| | | | | | | |
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| | | | | | | |

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|-----------------|
| Measured by: SL |
| Date: 10/12/16 |

| |
|-----------------|
| Audited by: B.A |
| Date: 10/12/16 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|------------|----------|
| A | 04.04.20 | New Issue | KJ/RF | |
| B | 06.10.24 | Dwg Rev. updated | KJ/JLM | BE |

| W/O: | | WORK ORDER CHANGES | | | | | |
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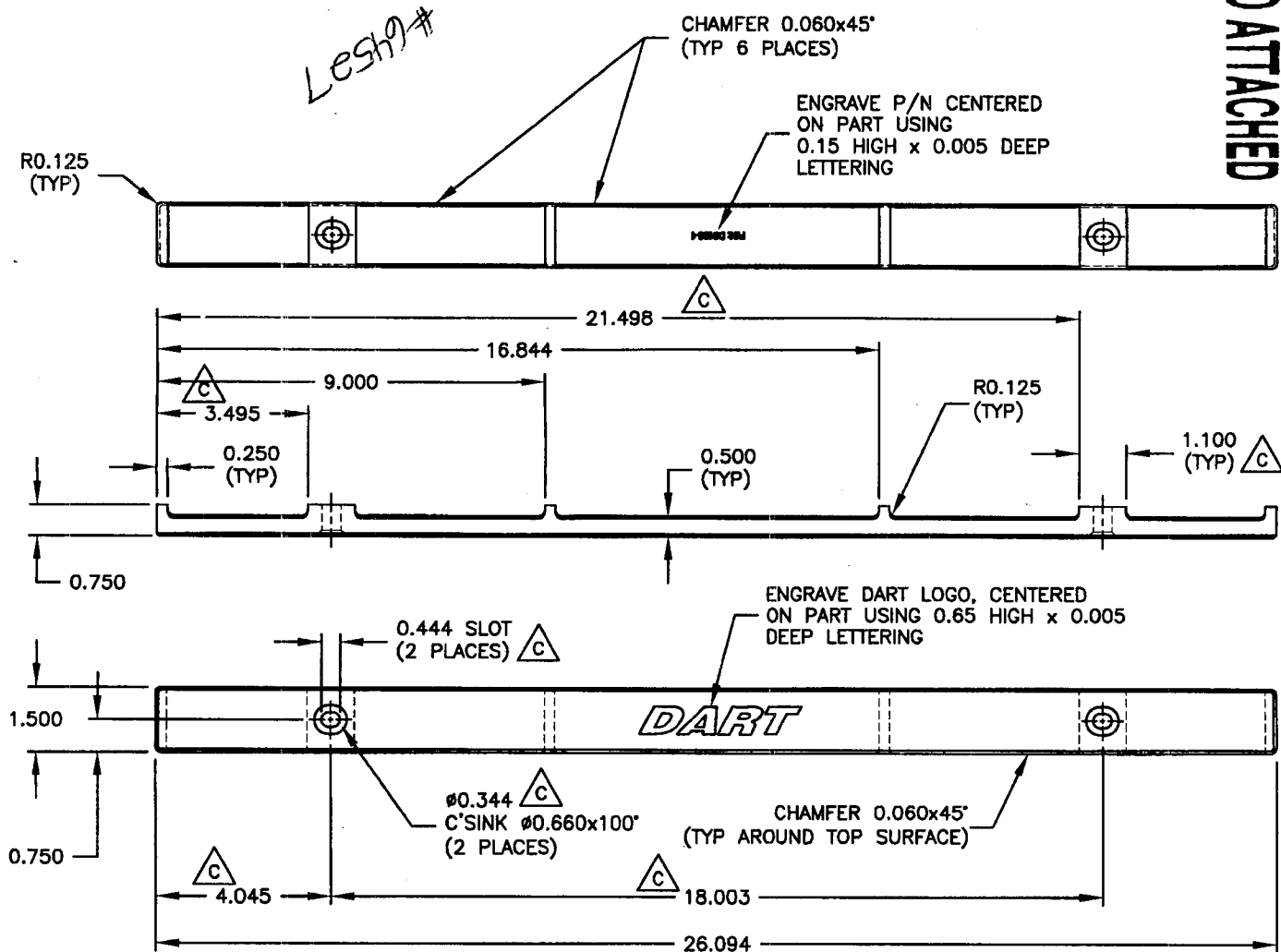
NOTE: Date & initial all entries

DART

de. 10. 31 ~~17~~

de. 10. 31

DEO ATTACHED



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

| | | | | | |
|---------|----------|----------|-------------|---|--------------|
| DESIGN | 90 | DRAWN BY | J.B. | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | APPROVED | [Signature] | DRAWING NO. | REV. C |
| DATE | 06.10.31 | | | D3196 | SHEET 1 OF 3 |
| | | | | TITLE | SCALE |
| | | | | BAR | 1:4 |
| A | | 03.06.25 | | NEW ISSUE | |
| B | | 06.09.25 | | ADD D3196-5 | |
| C | | 06.10.31 | | ADD SLOTS ON -1; REMOVED -5 | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

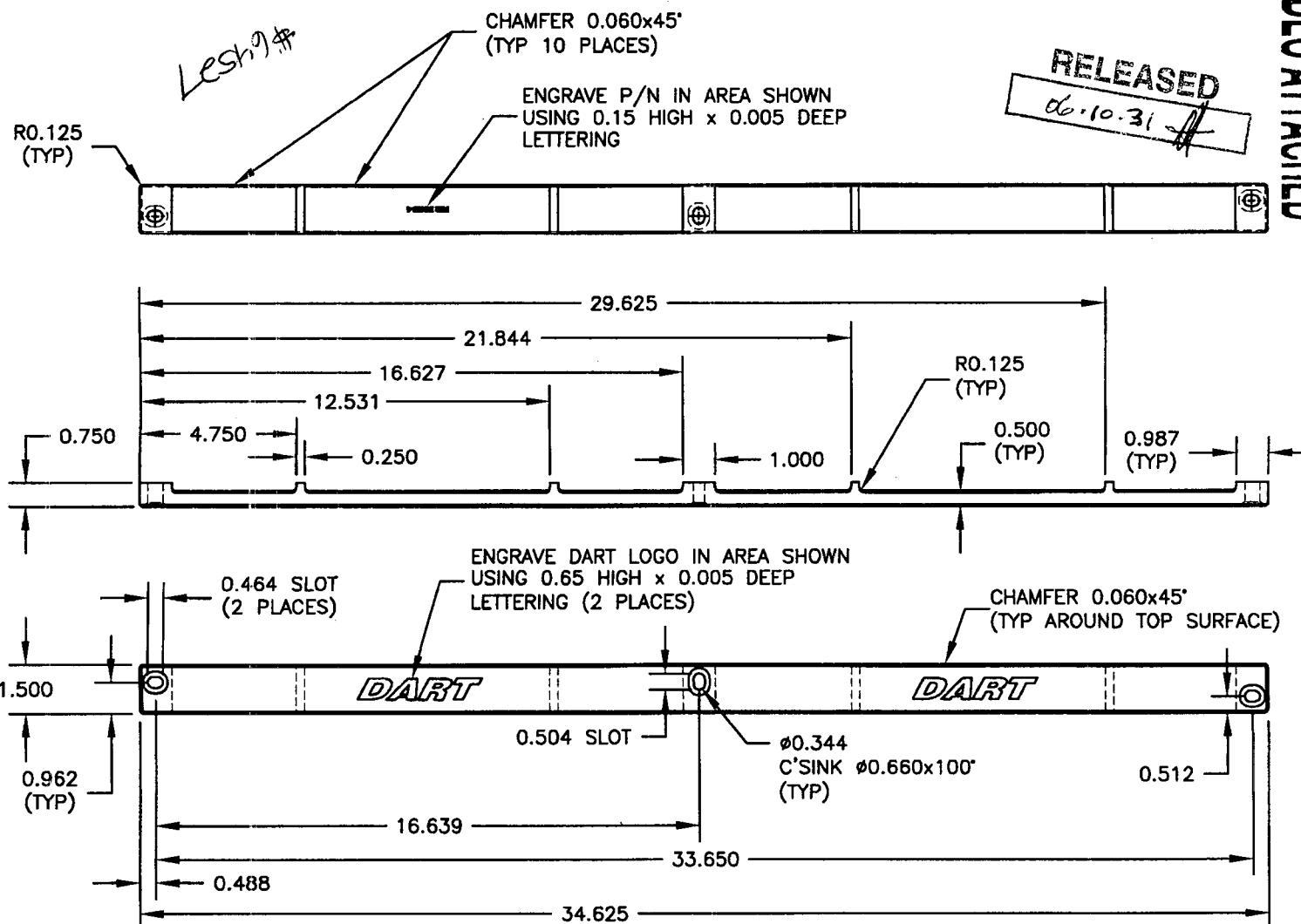
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

DEO ATTACHED

RELEASED
06.10.31



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

| | | | |
|----------|----------|--------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| CHECKED | APPROVED | DRAWING NO. | REV. C |
| PH | | D3196 | SHEET 3 OF 3 |
| DATE | TITLE | SCALE | |
| 06.10.31 | BAR | 1:5 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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|----------------------|-------------------------------|----------------------------------|---|--------------------------------|-------------------------|---------------------------|--------------|
| DRAWING NO. D3196 | TITLE BAR | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3196-C-1 | SHEET NO. SHEET 1 OF 2 | SCALE NTS |
| DRAWN <i>ASS</i> | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DE APPR. <i>[Signature]</i> | | | |
| DATE 08.08.27 | DATE 08.08.28 | DATE 08.08.29 | DATE 08.08.29 | DATE 08.08.29 | DATE 08.09.04 | | |

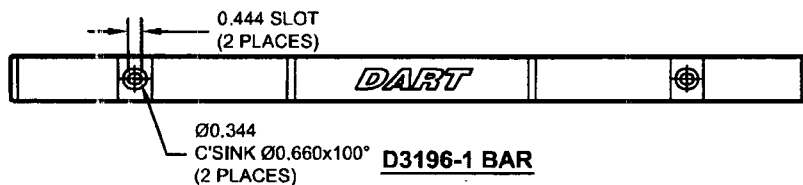
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IS:



D3196-1 BAR

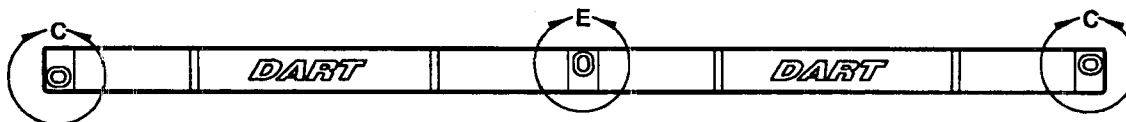
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D3196-1 BAR

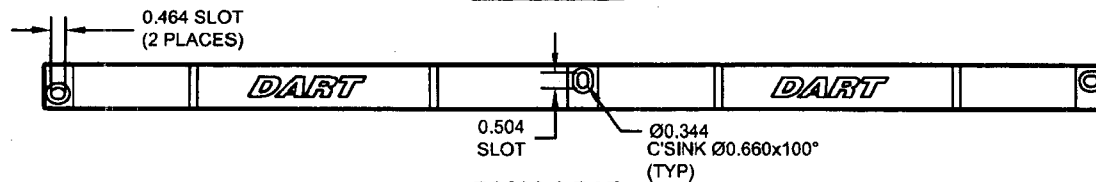
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IS:



D3196-3 BAR

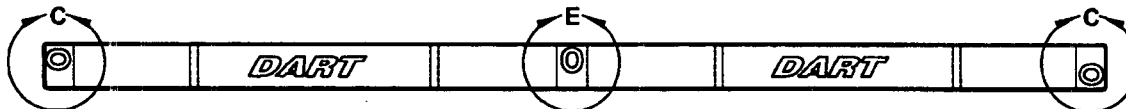
WAS:



D3196-3 BAR

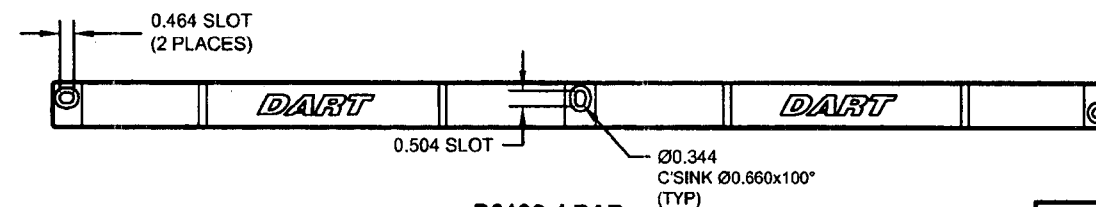
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IS:



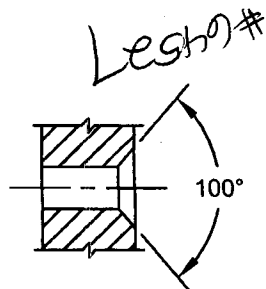
D3196-4 BAR

WAS:

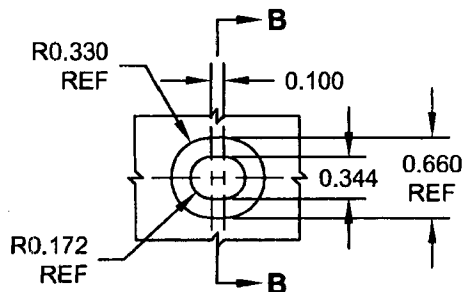


D3196-4 BAR

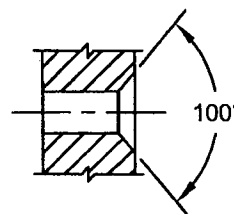
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|----------------------|-------------------------------|----------------------------------|---|--------------------------------|---------------------------|--------------|
| DRAWING NO. D3196 | TITLE BAR | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D3196-C-1 | SHEET NO. SHEET 2 OF 2 | SCALE NTS |
| DRAWN <i>ASS</i> | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DE APPR. <i>[Signature]</i> | | |
| DATE 08.08.27 | DATE 08.08.28 | DATE 08.08.29 | DATE 08.08.29 | DATE 08.08.29 | DATE 08.09.04 | |



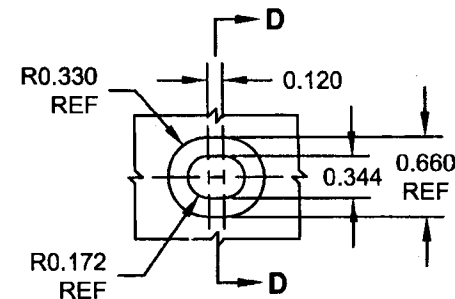
SECTION B-B



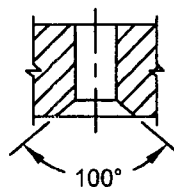
DETAIL A



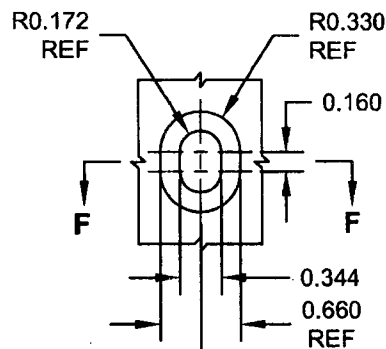
SECTION D-D



DETAIL C



SECTION F-F



DETAIL E

NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS
SEE NCR 08-051 FOR FURTHER INFORMATION
ALL OTHER INFORMATION REMAINS UNCHANGED

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